

859-2

Dart Aerospace Ltd.

Date: Tuesday, 10/30/2007 2:48:45 PM
 User: Kim Johnston

Process Sheet

Slit 2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 35438-2
 Estimate Number : 11198
 P.O. Number : N/A
 This Issue : 10/30/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 29825
 Written By :
 Checked & Approved By :
 Comment : Est: C 04.11.17 Step 13 revised KJ/JLM

Drawing Name : TUBE ASSEMBLY
 Part Number : D3304041
 Drawing Number : D3304 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 11/6/2007

Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0875W065 SS TUBING



Comment: Qty.: 1.4109 f(s)/Unit Total: 11.2871 f(s)
 Material: AISI 304/316 SS tubing 0.875" x 0.065" wall
 (M304TR0.875W.065)
 Identify for D3304-1
 Batch: M 103090 JAP 07/11/01 (8)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 Cut blank: 15.75" as per Dwg D3304
 Turn as per Folio FA458 and Dwg D3304
 Identify as D3304-1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr
 Drill as per Dwg D3304 using drill Jig D3304-T1
 Deburr

FF 07-11-02 (6)

Date: Tuesday, 10/30/2007 2:48:45 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 35438

Part Number: D3304041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Auto 8 (FC)

7.0

D33045

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bracket

Pick:

Qty Part Number Description Batch

1 D3304-5 Bracket *B 35481*

FC 07/11/19 (5)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bracket as per Dwg D3304 and QSI 004

FC 07/11/19 (5)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

acc 5 07/11/19 (5)

QC9 PD 07-11-19 (5)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 105642

BR 07-11-21

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. B.

07/11/21 (SX)

12.0

BLBS0016

PIP PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIP PIN

Pick:

Qty Part Number Description Batch

1 BLBS-0016 Pip Pin

M 16180 x 5 / 1 103178 x 2

FF 07-11-26

5

Date: Tuesday, 10/30/2007 2:48:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 35438

Part Number: D3304041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Loop Sleeve

Pick:

Qty

Part Number

Description

Batch

2

CBL-460

Loop Sleeve

M103927 x10

FF 07-11-26

5

14.0

CBL1240

Cable



Comment: Qty.: 1.0417 f(s)/Unit Total: 8.3336 f(s)

Cable

Pick:

Qty

Part Number

Description

Batch

12.5"

CBL-1240

Cable

M103927 x5

FF 07-11-26

5

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard and pip pin as per Dwg D3304

FF. 07-11-26

5

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 07/11/26

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: ST188

AS 07/11/27

(X5)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 07/11/27

(5)

Job Completion

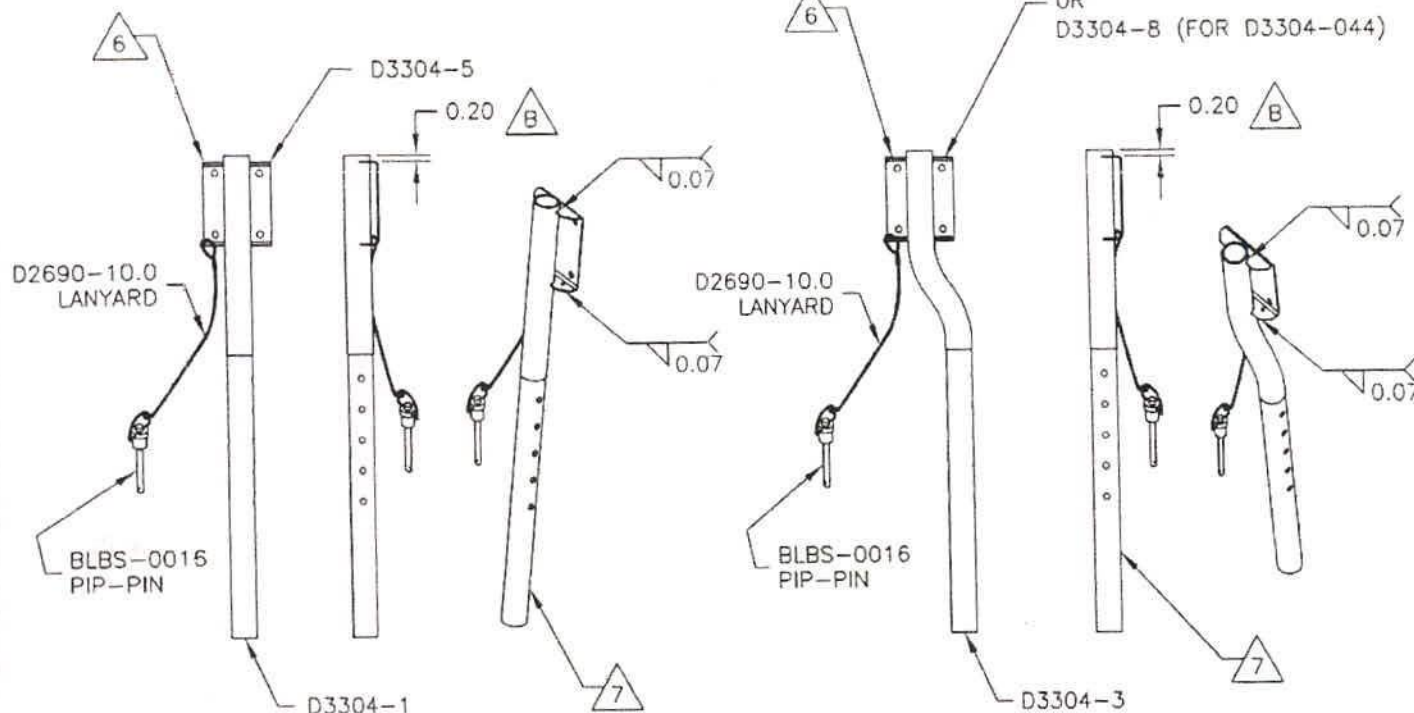


u 07-11-27

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
RF	RF	RF	RF	HAWKESBURY, ONTARIO, CANADA	REV B
CHECKED	APPROVED	DRAWING NO.	D3304	SHEET 1 OF 4	SCALE
DATE	05.07.15	TITLE	TUBE ASSEMBLY	1:6	
A	04.08.18	NEW ISSUE			
B	05.07.15	UPDATE DIMENSIONS: ADD D3304-7/-8			

D3304-7 (FOR D3304-043)
OR
D3304-8 (FOR D3304-044)



D3304-041 TUBE ASSEMBLY

**D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE**

D3304-041/-043/-044 NOTES:

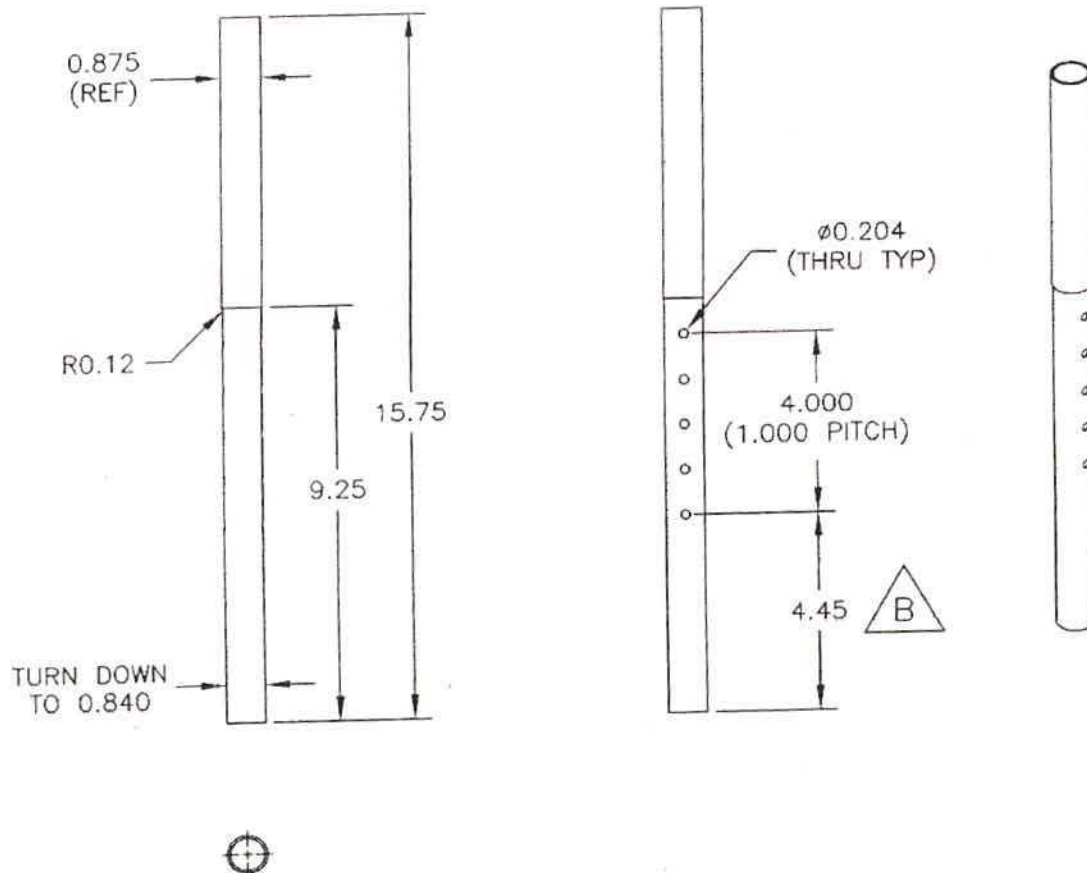
- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

RELEASED
05-08-11



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4

RELEASED
05 08 11 *[Signature]*



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

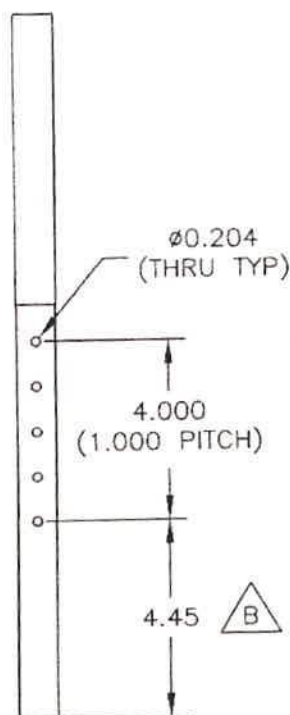
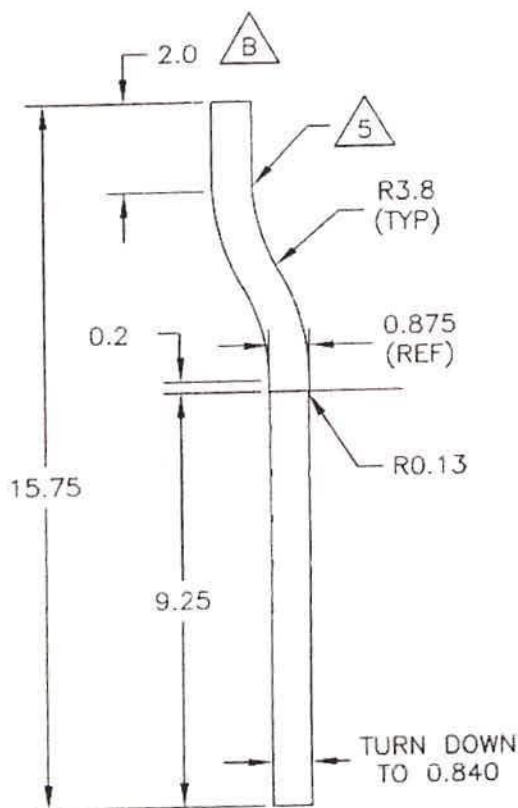
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DATE 05-08-11
NO 35438

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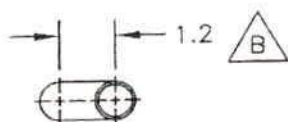
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4



RELEASED
05-08-11 *[Signature]*



D3304-3 TUBE

D3304-3 NOTES:

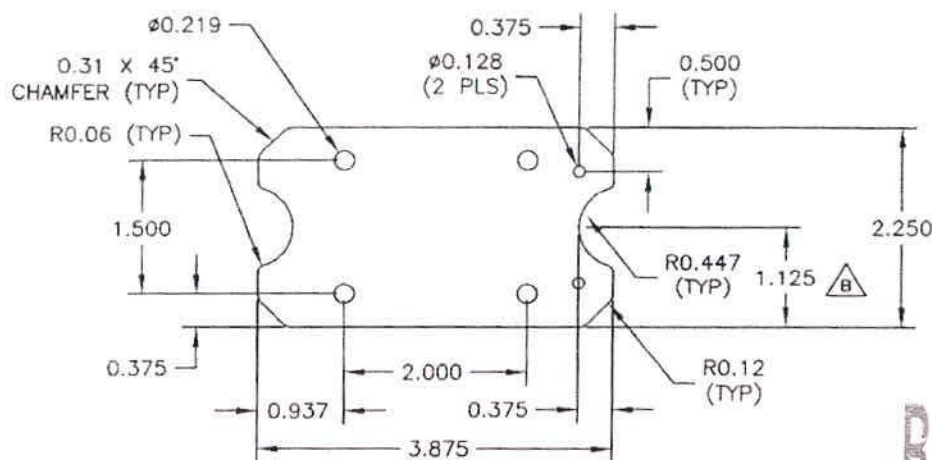
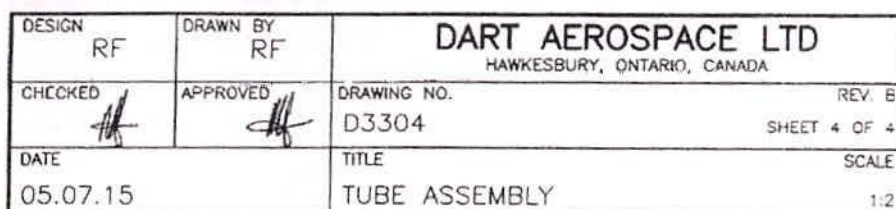
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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KEY TO THE
ENCLOSURE

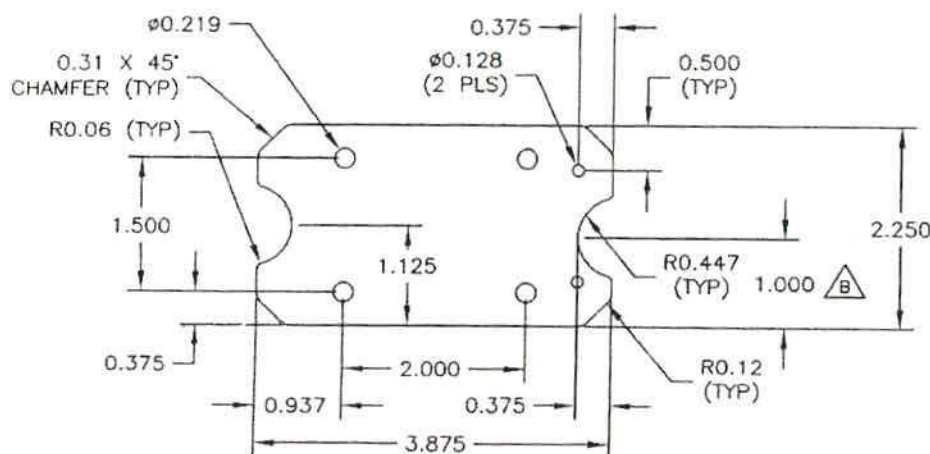
UNCONTROLLED COPY
SUBJECT: D3304-3
35438



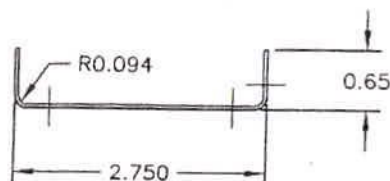
D3304-5 FLAT PATTERN



RELEASED
05-08-11



D3304-7/-8 FLAT PATTERN



D3304-5/-7 BRACKET
D3304-8 OPPOSITE

B

UNCONTROLLED
SUBJECT TO CONTROL
WITHOUT
WORK
NO. 35438

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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